

Work Order ID 101810

101810

Page 1

May-13-13 1:14:44 PM

Item ID: D3885-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Standard Web

Stop *NS2*

Start Date: 5/08/13 Start Qty: 4.00

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 13/05/14 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3885

B

0.00

0.00

0.00

0.00

100

1000

Purchasing

Purchasing

Memo

Purchasing

Issue P/O:

19892

Supplier: George A. Wright & Son Ltd.

Machine as per Dwg D3885

Conformity sheet required

CL 13/05/15 (8)

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

13/6/20 (8)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 101810

101810

Page 2

May 13-13 1:14:44 PM

Item ID: D3885-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 5/08/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00 *4*

Customer:

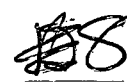

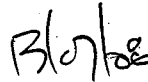
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				5/11/13		13/07/04	
140 *140* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Work Order ID 101810***101810***

Page 3

May-13-13 1:14:44 PM

Item ID: D3885-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Standard Web

Start Date: 5/08/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: LG

0.00

150

Packaging

Memo

0.00

Packaging

8 SAD 13-07-08

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/7/8 MF
13-7-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

May-13-13 1:14:44 PM

Page 1

Work Order ID: 101810

Parent Item: D3885-1

Parent Item Name: Standard Web

Start Date: 5/08/13

Required Date: 5/24/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 Extrusion "I" Beam		Manufactured	No			110	Each	67.0000	1	*8		05/13/13	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>	8			
						LG		67					
						93832		67					

D3885-1 P

x8

43/400 (8)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY			
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

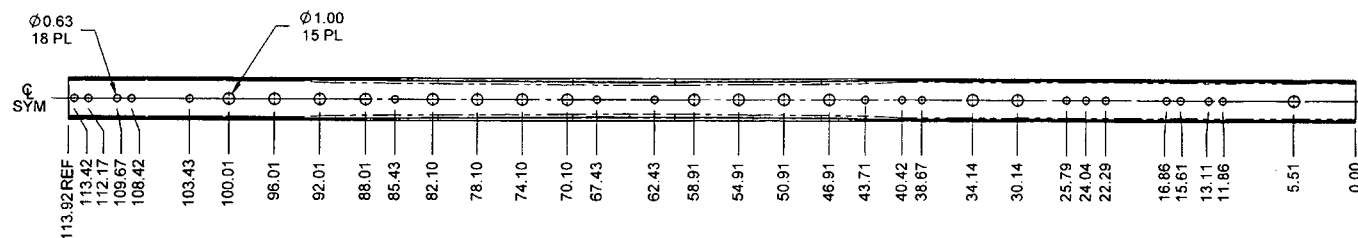
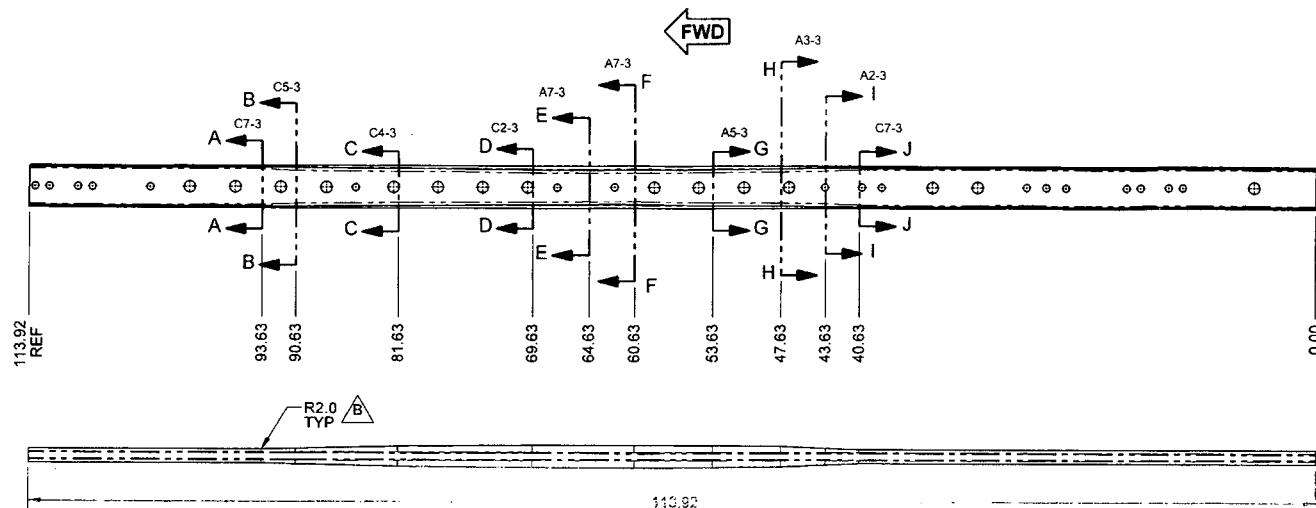
CL13/05/14
W/O. 10810

D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

RELEASED
06/05/14

B	ADD 0.32 (ZN D7-3, D6-3, D7-S, D6-S); ADD 0.24 (ZN B2-3, B3-S); ADD R2.0 TYP (ZN C8-2 & C8-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D3885-1 STANDARD WEB

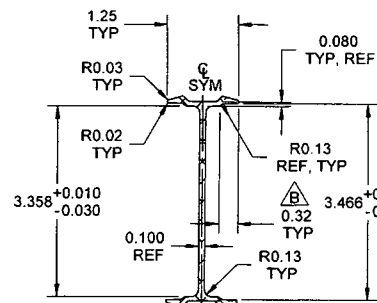
D3885-1 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

RELEASED
09/07/15

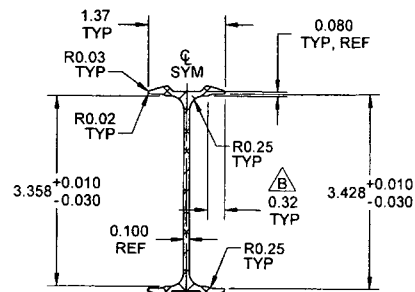
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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

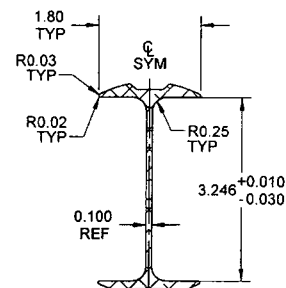


**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X

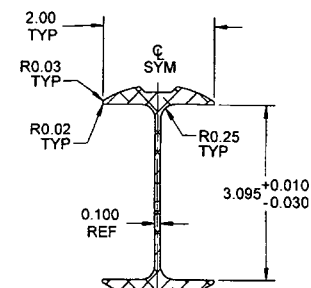
D7-4
D4-4
D3-4
D1-4



SECTION L-L D6-4
SCALE 5X

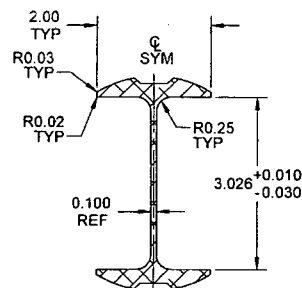


SECTION M-M D6-4
SCALE 5X

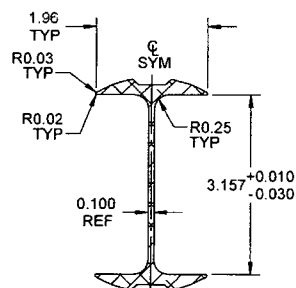


SECTION N-N D5-4
SCALE 5X

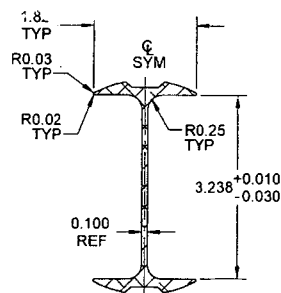
RELEASED
6/15/10



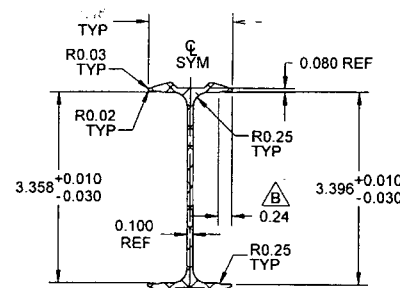
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



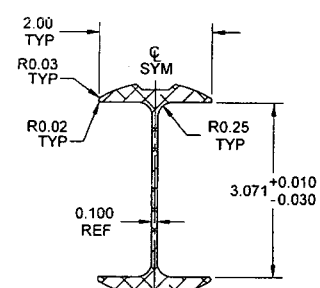
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X




SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE		09.06.30	
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8 7 6 5 4 3 2 1

Chantal Lavoie

From: Scott Dennis <scott@wejay.com>
Sent: Tuesday, June 18, 2013 1:42 PM
To: Chantal Lavoie
Subject: Fw: Dart PO19892 Documentation correction
Attachments: Inspection report-DART PO19892.pdf

Hi Chantal, please see below for Cliff's comments.
Thank you.

Scott

From: Clifford Smith
Sent: Tuesday, June 18, 2013 1:34 PM
To: 'Scott Dennis'
Subject: Dart PO19892 Documentation correction

Hi Scott,

The Inspection Test Report sent today with the 'Standard Webs', rel. Dart PO19892 had some errors.
I have attached a PDF of the corrected document.
Please forward this to Dart for me.

Thanks,

Cliff



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. **36306**

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# **P019892**

PART No. **D3885-1**

DESCRIPTION: **Standard Web**

DWG No. **D3885 - sheets 2-3**

REV. **B**

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR: *Chaffin*

QUANTITY
REC'D: **1**

ACCEPT: **1**

REJECT: **-**

N.C.R.# **--**

DATE: **JUNE 5, 2013**

INSTRUCTIONS, COMMENTS:

1ST ARTICLE

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	18 places	+ .008/- .001		✓	1	Acc.
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		✓	1	"
3	5.51"		+/- .03		✓	1	"
4	11.86"		+/- .03		✓	1	"
5	13.11"		+/- .03		✓	1	"
6	15.61"		+/- .03		✓	1	"
7	16.86"		+/- .03		✓	1	"
8	22.29"		+/- .03		✓	1	"
9	24.04"		+/- .03		✓	1	"
10	25.79"		+/- .03		✓	1	"
11	30.14"		+/- .03		✓	1	"
12	34.14"		+/- .03		✓	1	"
13	38.67"		+/- .03		✓	1	"
14	40.42"		+/- .03		✓	1	"
15	43.71"		+/- .03		✓	1	"
16	46.91"		+/- .03		✓	1	"
17	50.91"		+/- .03		✓	1	"
18	54.91"		+/- .03		✓	1	"
19	58.91"		+/- .03		✓	1	"
20	62.43"		+/- .03		✓	1	"
21	67.43"		+/- .03		✓	1	"
22	70.10"		+/- .03		✓	1	"
23	74.10"		+/- .03		✓	1	"
24	78.10"		+/- .03		✓	1	"
25	82.10"		+/- .03		✓	1	"
26	85.43"		+/- .03		✓	1	"
27	88.01"		+/- .03		✓	1	"
28	92.01"		+/- .03		✓	1	"
29	96.01"		+/- .03		✓	1	"
30	100.01"		+/- .03		✓	1	"
31	103.43"		+/- .03		✓	1	"
32	108.42"		+/- .03		✓	1	"
33	109.67"		+/- .03		✓	1	"

INSPECTION / TEST REPORT						JOB No. 36306	
						PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. P017892							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885				REV. B		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REV. NMR #)
34	112.67"		+/- .03		✓	1	Acc.
35	113.42"		+/- .03		✓	1	"
36	113.92" o.a.		+/- .03		✓	1	"
37	1.25" TYP	Section A-A, J-J	+/- .03		✓	1	"
38	R.03" TYP				✓	1	"
39	R.02" TYP				✓	1	"
40	3.358"		+0.010/-0.030		✓	1	"
41	R.13" TYP				✓	1	"
42	.32" TYP		+/- .03		✓	1	"
43	3.466"		+0.010/-0.030		✓	1	"
44	R.13" TYP				✓	1	"
45	.080 TYP, REF		+/- .03		✓	1	"
46	1.37" TYP	Section B-B			✓	1	"
47	R.03" TYP				✓	1	"
48	R.02" TYP				✓	1	"
49	3.358"		+0.010/-0.030		✓	1	"
50	R.25" TYP				✓	1	"
51	.32" TYP		+/- .03		✓	1	"
52	R.25" TYP				✓	1	"
53	3.428"		+0.010/-0.030		✓	1	"
54	1.80" TYP	Section C-C	+/- .03		✓	1	"
55	R.03" TYP				✓	1	"
56	R.02" TYP				✓	1	"
57	3.246"		+0.010/-0.030		✓	1	"
58	R.25" TYP				✓	1	"
59	2.00" TYP	Section D-D	+/- .03		✓	1	"
60	R.03" TYP				✓	1	"
61	R.02" TYP				✓	1	"
62	3.095"		+0.010/-0.030		✓	1	"
63	R.25" TYP				✓	1	"
64	2.00" TYP	Section E-E, F-F	+/- .03		✓	1	"
65	R.03" TYP				✓	1	"
66	R.02" TYP				✓	1	"
67	3.026"		+0.010/-0.030		✓	1	"
68	R.25" TYP				✓	1	"
69	1.96"	Section G-G	+/- .03		✓	1	"
70	R.03" TYP				✓	1	"
71	R.02" TYP				✓	1	"
72	3.157		+0.010/-0.030		✓	1	"



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19892

Purchase Order Date 5/15/2013

PO Print Date 5/15/2013

Page Number 1 of 1

VC-WMP001

Order From :

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Contact Name

Vendor Phone 613-384-1662

Vendor Fax 613-384-2997

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

COD

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
5/13/2013

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3885-1P	Standard Web	6/7/2013 Yes	8.00 Each	Day & Ross coll	\$550.0000	\$4,400.00

Special Inst: MACHINE AS PER DWG D3885 REV. B
B101810

PO Total:

\$4,400.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO

Change Nbr: 1

Change Date: 5/15/2013

NO GOODS RETURNED WITHOL
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: June. 17, 2013		
	P.O.# PO19892		
	WEJAY JOB# 36306		
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1P 'Standard Web'	8	Machined complete per drawing req'ts.	D3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. **36306**

PAGE: 1 of 3

CUSTOMER: **Dart Aerospace**

CUST. P.O.# **P019892**

PART No. **D3885-1**

DESCRIPTION: **Standard Web**

DWG No. **D3885 - sheets 2-3**

REV. **B**

E.C.O. **--**

MATERIAL: **Extrusions supplied by DAS**

INSPECTOR: *Chifford* **WMP 03**

QUANTITY
REC'D: **1**

ACCEPT: **1**

REJECT: **-**

N.C.R.# **--**

DATE:

JUNE 5, 2013

INSTRUCTIONS, COMMENTS:

1ST ARTICLE

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	18 places	+ .008/- .001		✓	1	Acc.
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		✓	1	"
3	5.51"		+/- .03		✓	1	"
4	11.86"		+/- .03		✓	1	"
5	13.11"		+/- .03		✓	1	"
6	15.61"		+/- .03		✓	1	"
7	16.86"		+/- .03		✓	1	"
8	22.29"		+/- .03		✓	1	"
9	24.04"		+/- .03		✓	1	"
10	25.79"		+/- .03		✓	1	"
11	30.14"		+/- .03		✓	1	"
12	34.14"		+/- .03		✓	1	"
13	38.67"		+/- .03		✓	1	"
14	40.42"		+/- .03		✓	1	"
15	43.71"		+/- .03		✓	1	"
16	46.91"		+/- .03		✓	1	"
17	50.91"		+/- .03		✓	1	"
18	54.91"		+/- .03		✓	1	"
19	58.91"		+/- .03		✓	1	"
20	62.43"		+/- .03		✓	1	"
21	67.43"		+/- .03		✓	1	"
22	70.10"		+/- .03		✓	1	"
23	74.10"		+/- .03		✓	1	"
24	78.10"		+/- .03		✓	1	"
25	82.10"		+/- .03		✓	1	"
26	85.43"		+/- .03		✓	1	"
27	88.01"		+/- .03		✓	1	"
28	92.01"		+/- .03		✓	1	"
29	96.01"		+/- .03		✓	1	"
30	100.01"		+/- .03		✓	1	"
31	103.43"		+/- .03		✓	1	"
32	108.42"		+/- .03		✓	1	"
33	109.67"		+/- .03		✓	1	"

INSPECTION / TEST REPORT						JOB No. 36306 PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO19892							
PART No.D3885-3				DESCRIPTION: Float Web			
DWG No.D3885				REV. B		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

34	112.67"		+/- .03		✓	1	Acc.
35	113.42"		+/- .03		✓	1	"
36	113.92" o.a.		+/- .03		✓	1	"
37	1.25" TYP	Section A-A, J-J	+/- .03		✓	1	"
38	R.03" TYP				✓	1	"
39	R.02" TYP				✓	1	"
40	3.358"		+0.010/-0.030		✓	1	"
41	R.13" TYP				✓	1	"
42	.32" TYP		+/- .03		✓	1	"
43	3.466"		+0.010/-0.030		✓	1	"
44	R.13" TYP				✓	1	"
45	.080 TYP, REF		+/- .03		✓	1	"
46	1.37" TYP	Section B-B			✓	1	"
47	R.03" TYP				✓	1	"
48	R.02" TYP				✓	1	"
49	3.358"		+0.010/-0.030		✓	1	"
50	R.25" TYP				✓	1	"
51	.32" TYP		+/- .03		✓	1	"
52	R.25" TYP				✓	1	"
53	3.428"		+0.010/-0.030		✓	1	"
54	1.80" TYP	Section C-C	+/- .03		✓	1	"
55	R.03" TYP				✓	1	"
56	R.02" TYP				✓	1	"
57	3.246"		+0.010/-0.030		✓	1	"
58	R.25" TYP				✓	1	"
59	2.00" TYP	Section D-D	+/- .03		✓	1	"
60	R.03" TYP				✓	1	"
61	R.02" TYP				✓	1	"
62	3.095"		+0.010/-0.030		✓	1	"
63	R.25" TYP				✓	1	"
64	2.00" TYP	Section E-E, F-F	+/- .03		✓	1	"
65	R.03" TYP				✓	1	"
66	R.02" TYP				✓	1	"
67	3.026"		+0.010/-0.030		✓	1	"
68	R.25" TYP				✓	1	"
69	1.96"	Section G-G	+/- .03		✓	1	"
70	R.03" TYP				✓	1	"
71	R.02" TYP				✓	1	"
72	3.157		+0.010/-0.030		✓	1	"

JOB No.

36306

PAGE: 3 of 3

CUST. P.O. PO 9892

PART No. D3885-3

DESCRIPTION: Float Web

DWG No.D3885

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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[illegible]

